






Work Order ID 57199



Monday, March 29, 2010 11:28:17 AM



ASAP


Page 1

Item ID: D3171-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Angle
Start Date: 3/29/2010 Start Qty: 10.00  Cust Item ID:
Required Date: 3/31/2010 Req'd Qty: 10.00  Customer:
Reference:


Approvals: Process Plan: mf Date: 10-3-29 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3171	Rev A


100  FLOW WATER JET 0.00
Waterjet
FLOW CNC Waterjet Memo 0.00
1-Cut as per Dwg D3171 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

10-3-30

110  QC2- Inspect parts off machine FAI/FAIB 0.00

QC Memo 0.00
Quality Control

10-3-30

120  QC8- Inspect parts - second check 0.00

QC Memo 0.00
Quality Control

5/6/30

work
X33

Pto →

Dart Aerospace Ltd

W/O: 57199		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/3/30	120	Took Qty +1 For QC inspection template	S	10/09/30	x1		S 10/09/30

Part No: D3171-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

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Required Date: 3/31/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Debur if necessary

0.00

0.00

140



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D3171 Tumble

0.00

0.00

SP 10/03/30

33

10-3-30

33

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/02/31

count

33

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Accept



Setup Start



Revision ID:

Stop



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Cust Item ID:

Required Date: 3/31/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 041

0.00



Packaging

Memo

0.00

Packaging

10/03/31 (33)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/31 A

10-3-31 (33)

Dart Aerospace Ltd

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Picklist Print

Monday, March 29, 2010 11:28:16 AM

Page 1

Work Order ID: 57199



Parent Item: D3171-1



Parent Item Name: Angle

Start Date: 3/29/2010



Required Date: 3/31/2010

Comments: IPP A 02.11.04 New Issue KJ

Start Qty: 10.00

Required Qty: 10.00

IPP Rev:B 08-03-27 now on water jet DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	139.4899	0.2168	.8		
												
304/316 Sheet .063												

B10-3-30

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT20	139.4898737	
106860	8.0295	
111924	25.1689737	
112442	29.8865	
113295	76.4049	

34

113295

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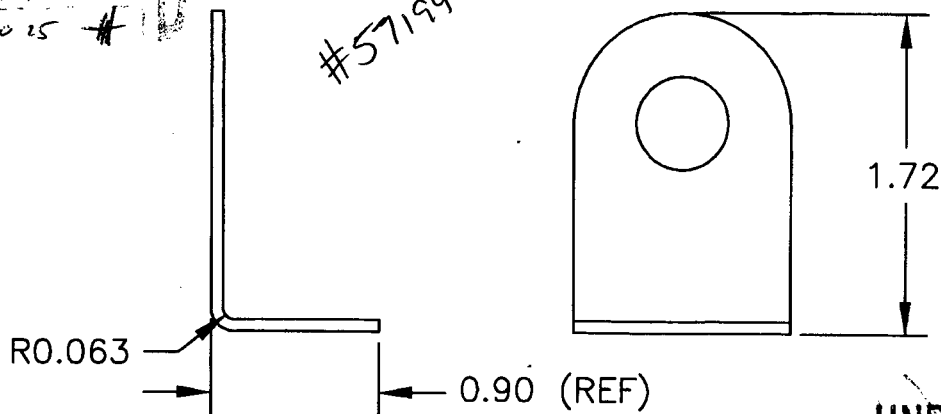
NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3171	REV. A SHEET 1 OF 1
DATE 02.10.08		TITLE ANGLE	SCALE 1:1
A	02.10.08	NEW ISSUE	

RELEASED
02.10.25 #

#57199



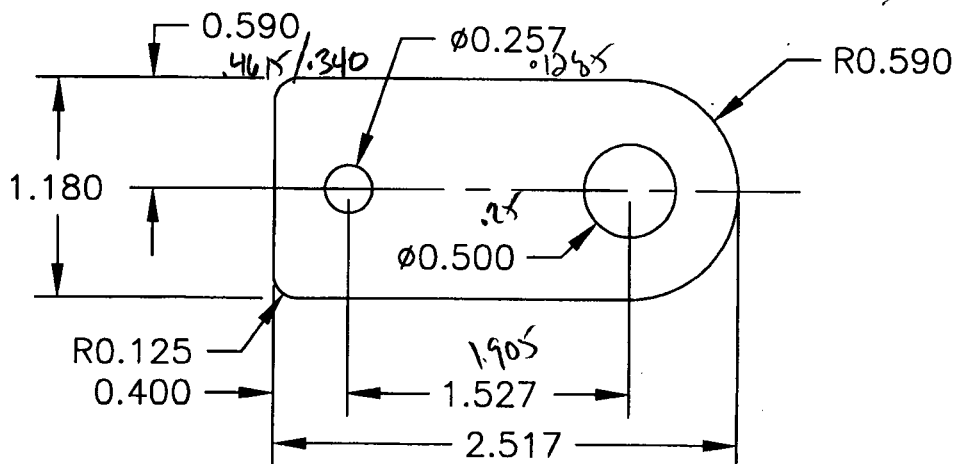
D3171-1 ANGLE

UNDER REVIEW

0.7.01.02 CB

adding -3

ok
CB
-3 not
being
used



D3171-1 ANGLE FLAT PATTERN

NOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS SHEET 0.063 THICK
PER MIL-S-5019 (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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